

Date: Monday, 11/05/2009 1:20:52 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRAME
Job Number : 47842	
Estimate Number : 13825	
P.O. Number :	Part Number : D225223
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D2252 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 46828	Material :
Written By :	Due Date : 22/05/2009 Qty: 42 Um: Each
Checked & Approved By : <u>JUD 09.05.11</u>	
Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



10



Comment: Qty.: 2.6775 f(s)/Unit Total : 5.3550 f(s)
 304 SQ Tube .75x.75x.065W
 batch: M11432

SAD 09-05-20 (C)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

**Comment:** LARGE FABRICATION RESOURCE 1

- 1- Cut as per dwg D2252
- 2- Deburr and remove identification markings on tube

SAD 09-05-20 (C)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09-05-21 (X4)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: WA

SAD 09-05-21 (X4)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------

**Comment:** FINAL INSPECTION/W/O RELEASE

09/05/2022

Job Completion



MF 09-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 111822

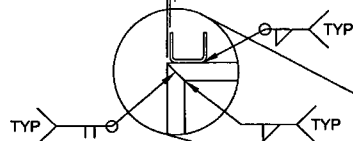
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

RELEASED
9/10/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JTB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

10 0.13
2 PL, REF



WELD ALL JOINTS
AS SHOWN

D2252-1

D2221-1

D2252-7

D2252-23

D2252-1

25.50
REF

D2327-3
REF
SEE DETAIL F
B2-5

31.19

D2989-19

31.19

D2581

TYP

D2581

30.00

34.50

30.00

REF

96.00±0.13

A

A D7-5






D2252-043 LID FRAME

RELEASED
09/02/03

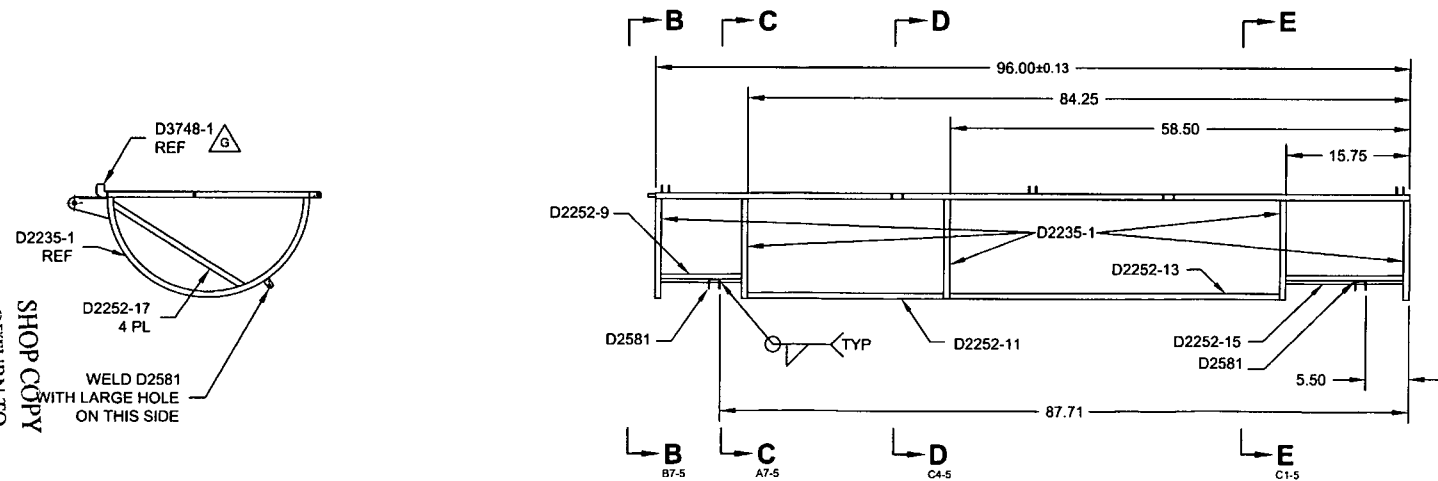
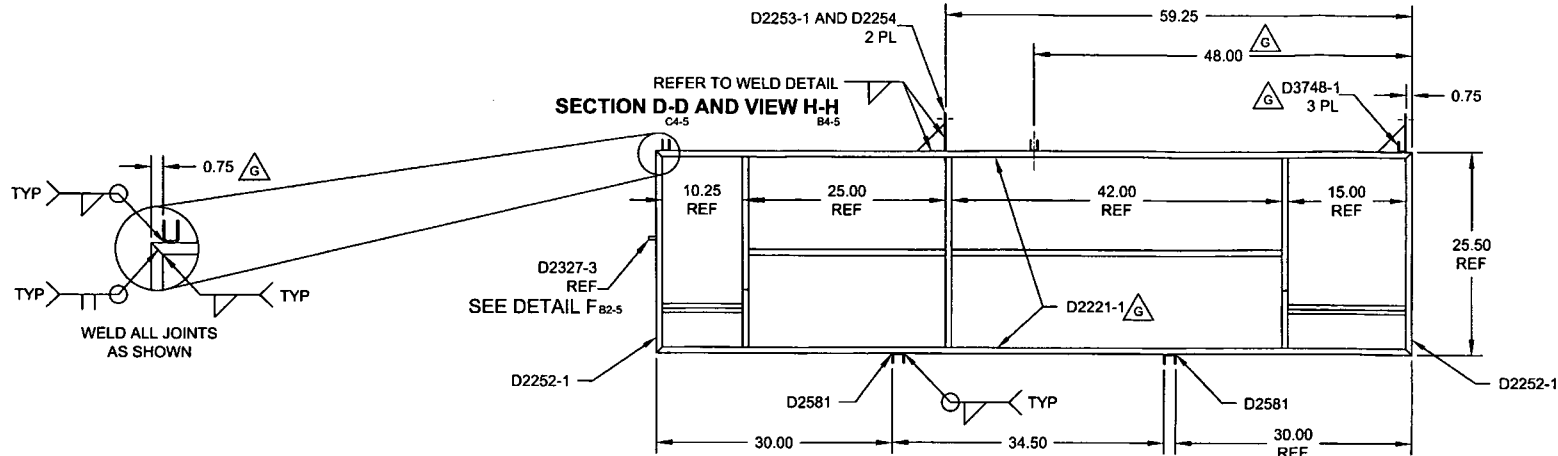
LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

G

DESIGN	B	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
18/03/03








D2252-041 BASE FRAME ASSEMBLY

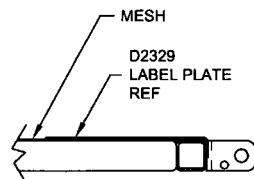
RELEASED
01/2/96

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

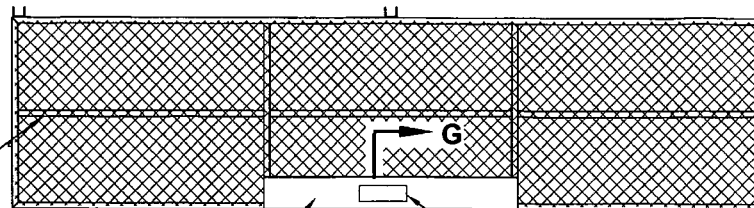
DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

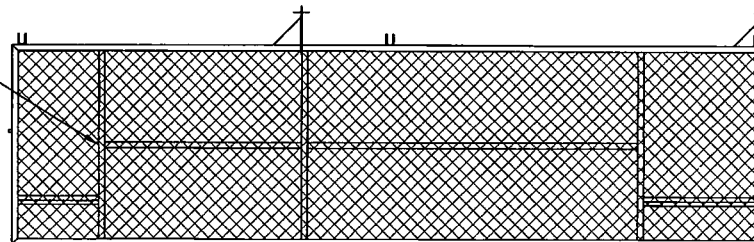


SECTION G-G C3-4
ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY

D3748-1
3 PL, REF

TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU

0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1

D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

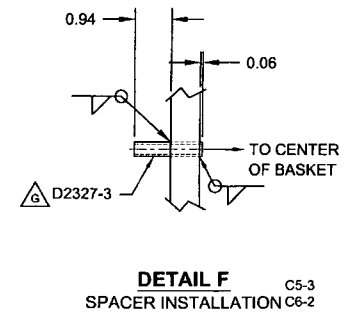
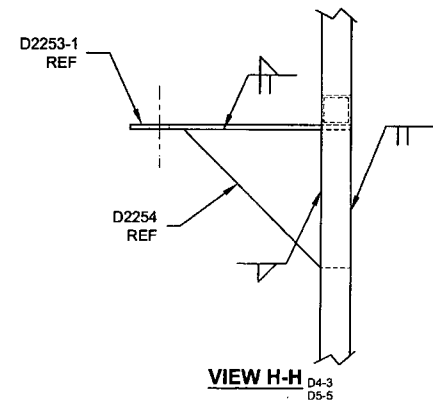
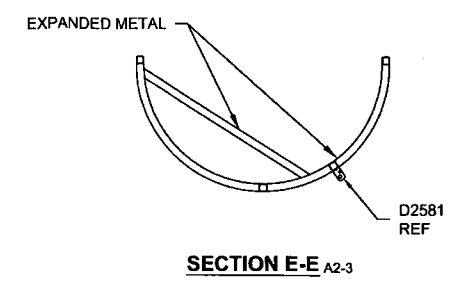
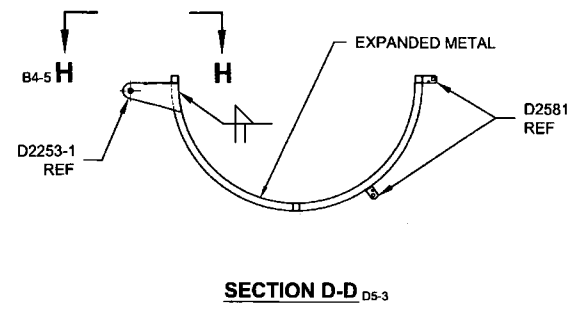
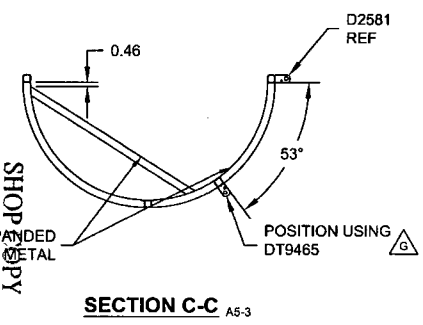
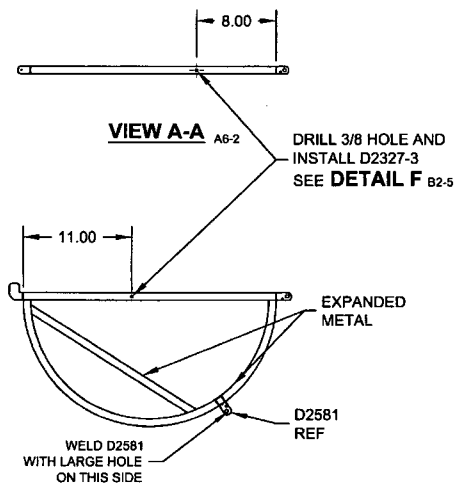
WITHOUT NOTICE

WORK ORDER

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

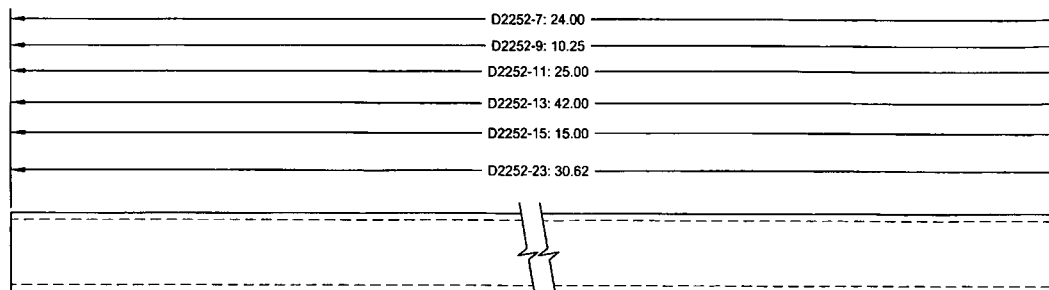
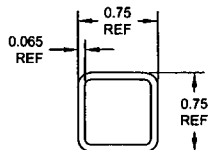


RELEASED
09/02/03

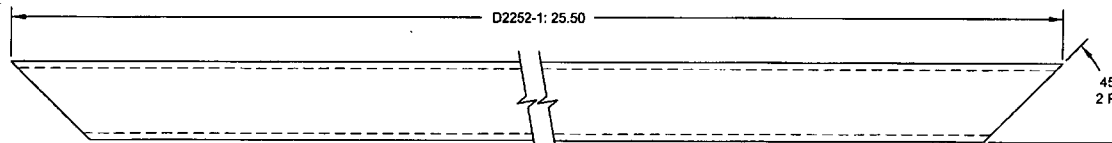
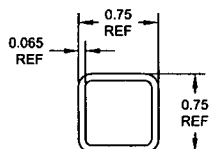
DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

NO. 17840
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

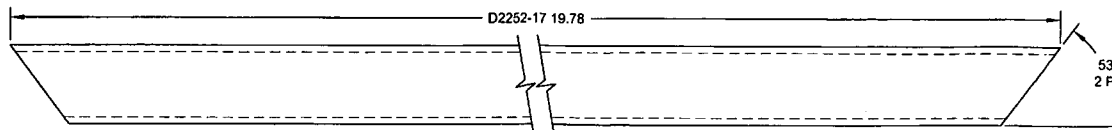
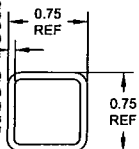
8 7 6 5 4 3 2 1



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME



D2252-1 FRAME



D2252-17 FRAME

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 ENGINEERING
 RETURN TO
 REFERENCE
 SHOP COPY

- NOTES:
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

RELEASED
 2/10/18/18

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2252	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1